

76913

# Work Order ID 86331

**\*86.331\***

June-27-12 1:26:47 PM

Item ID: D2620

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Item Name: Skidtube, 206 Skidtube

Stop **\*NS2\***

Start Date: 27/06/2012 Start Qty: 20.00

**\*20\***

Cust Item ID:

Required Date: 11/07/2012 Req'd Qty: 20.00

**\*20\***

Customer:

Reference:

Approvals:

Process Plan: ML5

Date: 12/06/27

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2620	Rev B

100		0.00
<b>*100*</b>	Skidtubes	
Skidtubes		
Skidtubes	Memo	0.00
	1-Bend extrusion as per Dwg D2620 using CNC Bending Machine program	
	206.A and Folio 150082 Cut Fwd end of tube as per Dwg D2620	

110	QC5- Inspect part completeness to step on W/O	0.00
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<b>*110*</b>		
QC	Memo	0.00
Quality Control		

120	Identify as per dwg & Stock Location: <u>46</u>	0.00
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<b>*120*</b>		
Packaging	Memo	0.00
Packaging		

CF 12-6-28

DP 12-6-28

DP 12-6-28

(20)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 86331****\*86.331\***

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June-27-12 1:26:47 PM

Item ID: D2620

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Skidtube, 206 Skidtube

Start Date: 27/06/2012 Start Qty: 20.00

**\*20\***

Cust Item ID:

Required Date: 11/07/2012 Req'd Qty: 20.00

**\*20\***

Customer:

Reference:

Approvals:

Process Plan: \_\_\_\_\_

Date: \_\_\_\_\_

Tooling: \_\_\_\_\_

Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Stop **\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130

QC21- Final Inspection - Work Order Release

0.00


**\*130\***

QC

Memo

0.00

Quality Control

12/6/29 MF  
12-06-28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

June-27-12 1:26:52 PM

Page 1

Work Order ID: 86331

\*86331\*

Parent Item: D2620

\*D2620\*

Parent Item Name: Skidtube, 206 Skidtube

Start Date: 27/06/2012

Required Date: 11/07/2012

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP D02.07.26Change Dwg to rev.B; Updated LocationRF

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D2600-1-160

Manufactured No

100

Each

75.0000

1

20

\*D2600-1-160\*

\*\*

Extrusion Round 3" 206

DP 12-6-28

Location

Loc Qty

Loc Code

LG

75

43969

2

59875

1

68284

4

76913

68

20

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

SHOP COPY

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SUBJECT TO AMENDMENT

WITHOUT NOTICE

WORK ORDER

NO. 06331 MLD

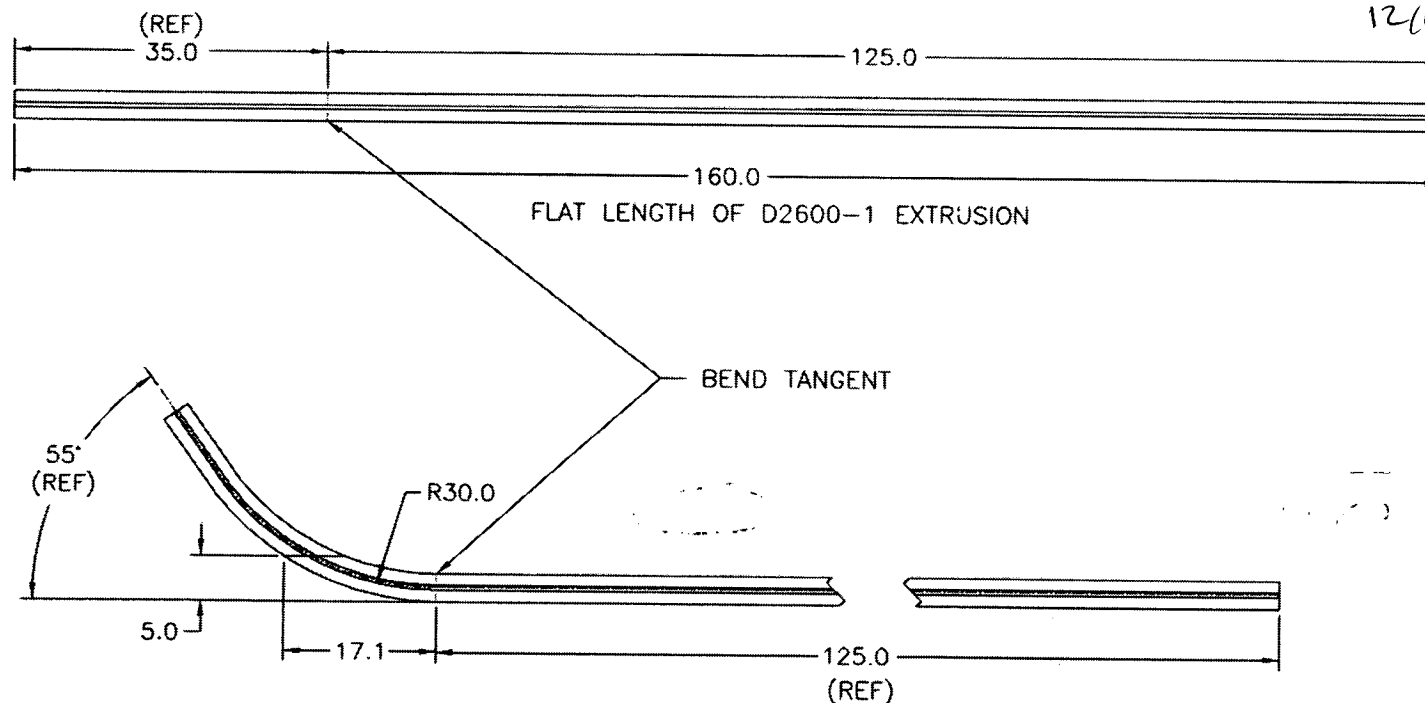
12/06/27

**DART**



# SPECIFICATION CONTROL DRAWING

## 206 SKIDTUBE BENDING



### DAMAGE TOLERANCE

1. THERE SHOULD BE NO VISIBLE WRINKLES BELOW 5.0 AFTER BENDING.
2. GOUGES UP TO 0.020 DEEP ARE ACCEPTABLE IN BENT PORTION OF THE TUBE. NO GOUGES ARE ACCEPTABLE IN THE FLAT PORTION OF THE TUBE. DEEPER GOUGES ARE ACCEPTABLE IN THE PORTION OF THE TUBE ABOVE 5.0.
3. TUBE WIDTH SHOULD BE  $3.20 \pm 0.200$  IN THE BEND. TUBE WIDTH SHOULD BE  $3.200 \pm 0.010$  IN THE FLAT PORTION OF THE TUBE.
4. TUBE HEIGHT SHOULD BE  $3.15 \pm 0.200$  IN THE BEND. TUBE HEIGHT SHOULD BE  $3.150 \pm 0.010$  IN THE FLAT PORTION OF THE TUBE.

NOTE: ALL DIMENSIONS ARE IN INCHES

**RELEASED**  
99.07.15 DS

DESIGN	DRAWN BY	TITLE	SCALE
99.09.10	RF	206 SKIDTUBE BENDING CONTROL	1:20
CHECKED	APPROVED	DRAWING NO. D2620	REV. B
DATE	DATE	DATE	SHEET 1 OF 1
99.09.10	97.11.07	97.09.10	
A	NEW ISSUE	UPDATE FOR IN-HOUSE BENDING	
B			

DART AEROSPACE USA, INC.  
FAIRCHILD INTERNATIONAL AIRPORT, WA

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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